

April-02-12 3:08:25 PM

Ship May 4th

Page 1

Setup Start *NS1*

Stop ***NS2***

Customer:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

C

0.00

0.00

Memo

0.00

0.00

Memo

0.00

0.00

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82526

April-02-12 3:08:25 PM

82526

Page 2

Item ID: D4030-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Assembly, Light Lid (350)
 Start Date: 02/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 04/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

PP 82525

12/5/04

ML 12/05/04
 ME 12-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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82526

D4030-043

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530		Manufactured	No			100	Each	4.0000	1	1			
D2530									**				
Handle Weldment										82895	JB		

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST504	34	
77488	34	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST504	24	
77055	24	

382528 (a)**

1 *ES 2/05/04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 82526

82526

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3915-041

Manufactured No

100 Each 0.0000

1 1

D3915-041

Light Lid Assembly, Long Basket

D3917-3

Manufactured No

100 Each 97.0000

6 6

D3917-3

Washer

82532 382527

**

**

JB 12/05/04

Location

Loc Qty

Loc Code

ST070

97

76956

4

80598

1

81205

92

81205

D3953-3

Manufactured No

100 Each 34.0000

2 2

D3953-3

Gas Spring Stud, Lid

**

JB

Location

Loc Qty

Loc Code

ST075

34

78042

18

82044

16

82044

D3953-7

Manufactured No

100 Each 44.0000

2 2

D3953-7

Spring Spacer

**

JB 12/05/01

Location

Loc Qty

Loc Code

ST075

44

76295

4

82045

40

82045

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

April-02-12 3:08:28 PM

Page 3

Work Order ID: 82526

82526

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100 Each 60.0000 2 2 ✓

D3953-9

Gas Spring Washer

**

JB

Location

Loc Qty

Loc Code

ST075

60

78916

8

82035

52

82035

D3953-17 Manufactured No

100 Each 35.0000 2 2 ✓

D3953-17

Gas Spring Spacer

**

JB

Location

Loc Qty

Loc Code

ST075

35

81206

24

81454

11

81206

D3953-19 Manufactured No

100 Each 10.0000 1 1 ✓

D3953-19

Gas Spring Bracket

**

82938 JB

Location

Loc Qty

Loc Code

ST075

10

75227

10

D3953-21 Manufactured No

100 Each 27.0000 1 1 ✓

D3953-21

Gas Spring Bracket

**

JB 12/05/07

Location

Loc Qty

Loc Code

ST075

27

81207

21

81456

6

81207

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

April-02-12 3:08:29 PM

Page 4

Work Order ID: 82526

82526

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3

Manufactured No

100

Each

30.0000

1

1

✓

D3969-3

Spring (Basket Lid)

**

JB

Location

Loc Qty

Loc Code

ST272

30

64285

1

73515

9

81887

20

73515

AN3-14A

Purchased No

100

Each

80.0000

4

4

✓

AN3-14A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST352

80

119328

80

119328

AN3-20A

Purchased No

100

Each

126.0000

2

2

✓

AN3-20A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST352

126

115371

26

117441

100

115371

AN4-12

Purchased No

100

Each

77.0000

3

3

✓

AN4-12

Bolt

**

JB

12/05/01

Location

Loc Qty

Loc Code

ST357

77

118626

2

119775

25

120986

50

120986

April-02-12 3:08:29 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-02-12 3:08:29 PM

Page 5

Work Order ID: 82526

82526

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

160.0000

2

2

**

✓

JB

AN5-17A

Bolt

Location

Loc Qty

Loc Code

338

100

121181

100

121181

ST338

60

117872

42

120498

18

AN5-21A

Purchased

No

100

Each

32.0000

2

2

**

✓

JB

AN5-21A

Bolt

Location

Loc Qty

Loc Code

ST338

32

114714

32

114714

AN310-4

Purchased

No

100

Each

88.0000

3

3

**

✓

1x121444 JB

12/05/01

AN310-4

NUT

Location

Loc Qty

Loc Code

ST344

88

120124

13

120518

25

121011

25

121162

25

2x121162

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

April-02-12 3:08:29 PM

Page 6

Work Order ID: 82526

82526

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

100

Each

82.0000

2

2

AN310C4

Nut

**

Location

Loc Qty

Loc Code

ST344

82

119324

2

120360

30

121166

50

121166

6

MS21042L3

Purchased

No

100

Each

2,541.000

6

MS21042L3

Nut

**

121349

Location

Loc Qty

Loc Code

ST300

2541

117441

16

117885

32

118451

5

118927

3

119017

2219

119075

166

121162

100

MS21042L5

Purchased

No

100

Each

1,517.000

4

4

MS21042L5

Nut

**

JB

12/05/01

Location

Loc Qty

Loc Code

ST300

1517

116105

5

116548

43

117611

42

119109

1427

119109

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-02-12 3:08:29 PM

Page 7

Work Order ID: 82526

82526

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

296.0000

3

3

✓

MS24665-151

Cotter Pin

**

JB

Location

Loc Qty

Loc Code

ST309

296

17566

296

17566

MS24665-300

Purchased

No

100

Each

201.0000

2

2

✓

MS24665-300

Cotter Pin

**

JB

Location

Loc Qty

Loc Code

GA

197

118234

197

118234

ST309

4

116823

4

NAS1149F0432P

Purchased

No

100

Each

240.0000

6

6

✓

NAS1149F0432P

Washer

**

121415 *JB*

Location

Loc Qty

Loc Code

ST275

240

121060

40

121166

200

NAS1149F0563P

Purchased

No

100

Each

77.0000

4

4

✓

NAS1149F0563P

Washer

**

JB 12/05/01

Location

Loc Qty

Loc Code

ST275

77

117735

77

117735

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-02-12 3:08:29 PM

Page 8

Work Order ID: 82526

82526

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

590.0000

8

8

✓

NAS1149F0332P

WASHER

Location

Loc Qty

Loc Code

ST275

590

117735

37

119225

10

120910

200

120986

200

121166

140

17317

3

120910

NAS1149C0432R

Purchased

No

100

Each

2,278.000

2

2

✓

NAS1149C0432R

Washer

Location

Loc Qty

Loc Code

ST297

2278

117291

1278

119124

1000

117291

JB 12/05/01/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

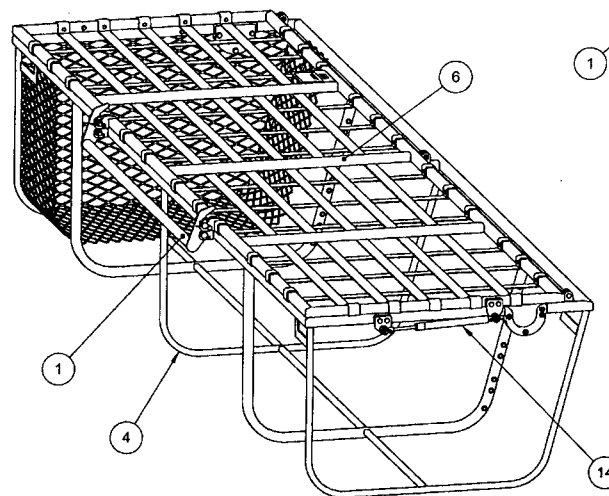
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

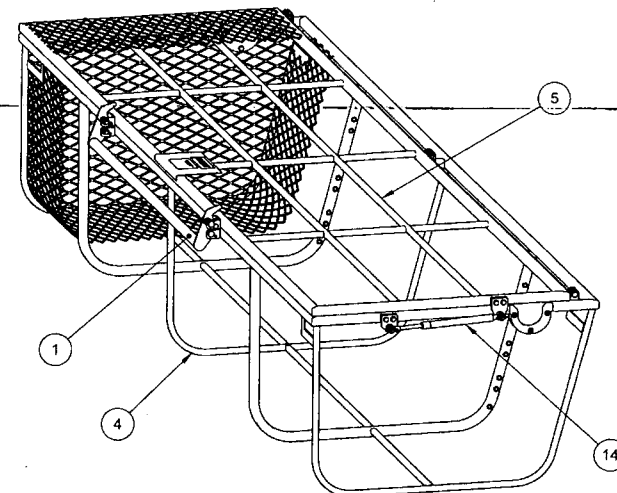
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET, LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82526 MCT

12/04/02

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
10-08-12 G
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4030 TITLE LONG BASKET ASSY (350) SHEET 1 OF 3 SCALE REV. C NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

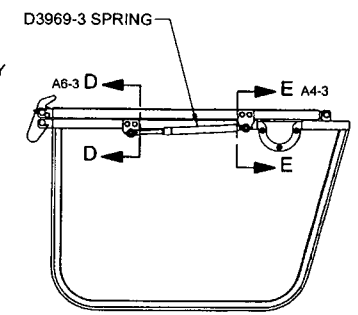
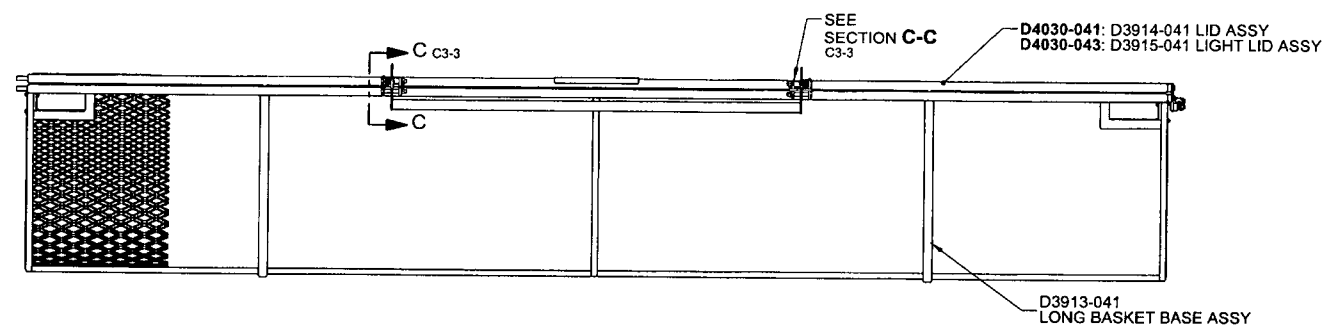
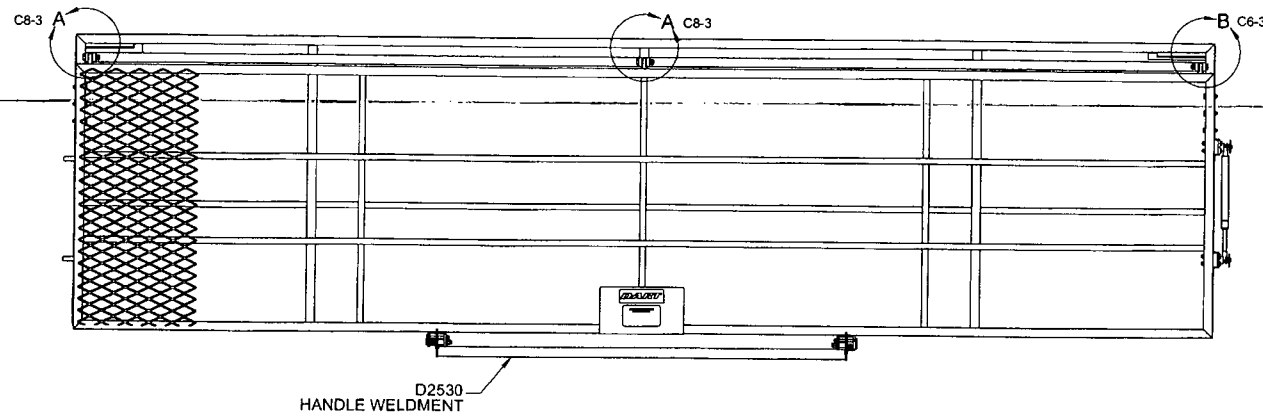
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82526



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY. LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12 CP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SEP 10 2010	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350) _____ NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

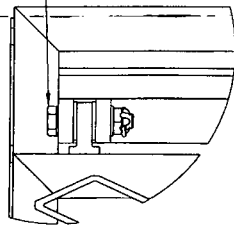
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

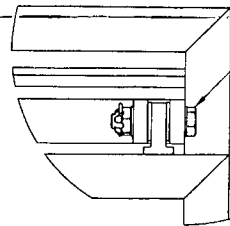
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



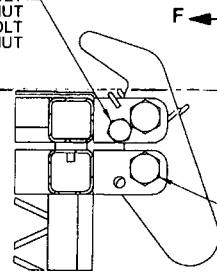
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

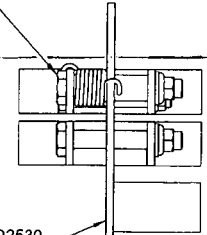


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350)	
DATE	10.07.23	NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries